Section 1. Registration Information

Source Identification

Facility Name:	Ajinomoto Foods North America
Parent Company #1 Name:	
Parent Company #2 Name:	

Submission and Acceptance

Submission Type:	Re-submission
Subsequent RMP Submission Reason:	5-year update (40 CFR 68.190(b)(1))
Description:	
Receipt Date:	09-Nov-2022
Postmark Date:	09-Nov-2022
Next Due Date:	09-Nov-2027
Completeness Check Date:	09-Nov-2022
Complete RMP:	Yes
De-Registration / Closed Reason:	
De-Registration / Closed Reason Other Text:	
De-Registered / Closed Date:	
De-Registered / Closed Effective Date:	
Certification Received:	

Facility Identification

EPA Facility Identifier:	1000 0023 6951
Other EPA Systems Facility ID:	
Facility Registry System ID:	

Dun and Bradstreet Numbers (DUNS)

Facility DUNS:	
Parent Company #1 DUNS:	786282921
Parent Company #2 DUNS:	

Facility Location Address

Street 1:	3131 S.Quail Avenue
Street 2:	
City:	Joplin
State:	MISSOURI
ZIP:	64804
ZIP4:	
County:	JASPER

Facility Latitude and Longitude

Latitude (decimal):	37.055076
Longitude (decimal):	-94.394033
Lat/Long Method:	Interpolation - Satellite
Lat/Long Description:	Center of Facility
Horizontal Accuracy Measure:	40
Horizontal Reference Datum Name:	North American Datum of 1983
Source Map Scale Number:	

Owner or Operator

Operator Name:	Ajinomoto Foods North America
Operator Phone:	(909) 477-4700

Mailing Address

Operator Street 1:	4200 Concours Drive
Operator Street 2:	Suite #100
Operator City:	Ontario
Operator State:	CALIFORNIA
Operator ZIP:	91764
Operator ZIP4:	
Operator Foreign State or Province:	
Operator Foreign ZIP:	
Operator Foreign Country:	

Name and title of person or position responsible for Part 68 (RMP) Implementation

RMP Name of Person:	Vernon Freelend
RMP Title of Person or Position:	Maintenance Manager
RMP E-mail Address:	vernon.freelend@ajinomotofoods.com

Emergency Contact

Emergency Contact Name:	Vernon Freelend
Emergency Contact Title:	Maintenance Manager
Emergency Contact Phone:	(417) 313-2236
Emergency Contact 24-Hour Phone:	(471) 313-2236
Emergency Contact Ext. or PIN:	
Emergency Contact E-mail Address:	vernon.freelend@ajinomotofoods.com

Other Points of Contact

Facility or Parent Company E-mail Address:	
Facility Public Contact Phone:	(909) 477-4700
Facility or Parent Company WWW Homepage Address:	www.ajinorthamerica.com

Local Emergency Planning Committee

LEPC:	Jasper County LEPC

Full Time Equivalent Employees

Number of Full Time Employees (FTE) on Site:	250
FTE Claimed as CBI:	

Covered By

OSHA PSM :	Yes
EPCRA 302 :	Yes
CAA Title V:	

Air Operating Permit ID:

OSHA Ranking

OSHA Star or Merit Ranking:

Last Safety Inspection

Last Safety Inspection (By an External Agency) Date:	01-Apr-2022
Last Safety Inspection Performed By an External Agency:	Sampo

Predictive Filing

Did this RMP involve predictive filing?:

Preparer Information

Preparer Name:	John Phillips
Preparer Phone:	(262) 781-5757
Preparer Street 1:	W141N9501 Fountain Blvd.
Preparer Street 2:	
Preparer City:	Menomonee Falls
Preparer State:	WISCONSIN
Preparer ZIP:	53051
Preparer ZIP4:	
Preparer Foreign State:	
Preparer Foreign Country:	
Preparer Foreign ZIP:	

Confidential Business Information (CBI)

CBI Claimed:
Substantiation Provided:
Unsanitized RMP Provided:

Reportable Accidents

Reportable Accidents: See Section 6. Accident History below to determine if there were any accidents reported for this RMP.

Process Chemicals

Process ID:	1000128190
Description:	Ammonia Refrigeration
Process Chemical ID:	1000160732
Program Level:	Program Level 3 process
Chemical Name:	Ammonia (anhydrous)
CAS Number:	7664-41-7
Quantity (lbs):	32024
CBI Claimed:	
Flammable/Toxic:	Toxic

Process NAICS

Process ID:	1000128190
Process NAICS ID:	1000129584
Program Level:	Program Level 3 process
NAICS Code:	311412
NAICS Description:	Frozen Specialty Food Manufacturing

Section 2. Toxics: Worst Case

Toxic Worst ID: 1000103483

Percent Weight:	100.0
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP*Comp(TM)
Release Duration (mins):	10
Wind Speed (m/sec):	1.5
Atmospheric Stability Class:	F
Topography:	Urban

Passive Mitigation Considered

Dikes:	
Enclosures:	Yes
Berms:	
Drains:	
Sumps:	
Other Type:	

Section 3. Toxics: Alternative Release

Toxic Alter ID: 1000109935

Percent Weight:	100.0
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP*Comp(TM)
Wind Speed (m/sec):	3.0
Atmospheric Stability Class:	D
Topography:	Urban

Passive Mitigation Considered

Dikes:	
Enclosures:	
Berms:	
Drains:	
Sumps:	
Other Type:	

Active Mitigation Considered

Sprinkler System:	Yes
Deluge System:	
Water Curtain:	
Neutralization:	
Excess Flow Valve:	
Flares:	
Scrubbers:	
Emergency Shutdown:	Yes
Other Type:	

Section 4. Flammables: Worst Case

No records found.

Section 5. Flammables: Alternative Release

No records found.

Section 6. Accident History

No records found.

Section 7. Program Level 3

Description

No description available.

Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID:	1000138777
Chemical Name:	Ammonia (anhydrous)
Flammable/Toxic:	Toxic
CAS Number:	7664-41-7

Process ID:	1000128190
Description:	Ammonia Refrigeration
Prevention Program Level 3 ID:	1000110478
NAICS Code:	311412

Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):	19-Apr-2022

Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA update):	19-Apr-2022

The Technique Used

What If:	
Checklist:	
What If/Checklist:	Yes
HAZOP:	
Failure Mode and Effects Analysis:	
Fault Tree Analysis:	
Other Technique Used:	
PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):	18-Apr-2025

Major Hazards Identified

Toxic Release:	Yes
Fire:	Yes
Explosion:	Yes
Runaway Reaction:	
Polymerization:	
Overpressurization:	Yes
Corrosion:	Yes
Overfilling:	Yes
Contamination:	Yes
Equipment Failure:	Yes
Loss of Cooling, Heating, Electricity, Instrument Air:	Yes

Earthquake:	
Floods (Flood Plain):	
Tornado:	Yes
Hurricanes:	
Other Major Hazard Identified:	

Process Controls in Use

Vents:	
Relief Valves:	Yes
Check Valves:	Yes
Scrubbers:	
Flares:	
Manual Shutoffs:	Yes
Automatic Shutoffs:	Yes
Interlocks:	Yes
Alarms and Procedures:	Yes
Keyed Bypass:	
Emergency Air Supply:	
Emergency Power:	Yes
Backup Pump:	Yes
Grounding Equipment:	Yes
Inhibitor Addition:	
Rupture Disks:	
Excess Flow Device:	
Quench System:	
Purge System:	Yes
None:	
Other Process Control in Use:	

Mitigation Systems in Use

Sprinkler System:	Yes
Dikes:	
Fire Walls:	Yes
Blast Walls:	
Deluge System:	
Water Curtain:	
Enclosure:	Yes
Neutralization:	
None:	
Other Mitigation System in Use:	

Monitoring/Detection Systems in Use

Process Area Detectors:	Yes
Perimeter Monitors:	
None:	
Other Monitoring/Detection System in Use:	

Changes Since Last PHA Update

Reduction in Chemical Inventory:	
Increase in Chemical Inventory:	Yes
Change Process Parameters:	

Installation of Process Controls:	
Installation of Process Detection Systems:	
Installation of Perimeter Monitoring Systems:	
Installation of Mitigation Systems:	
None Recommended:	
None:	
Other Changes Since Last PHA or PHA Update:	

Review of Operating Procedures

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures):	14-Dec-2021

Training

Training Revision Date (The date of the most recent review or revision of training programs):	14-Apr-2021

The Type of Training Provided

Classroom:	Yes
On the Job:	Yes
Other Training:	

The Type of Competency Testing Used

Written Tests:	
Oral Tests:	
Demonstration:	Yes
Observation:	Yes
Other Type of Competency Testing Used:	

Maintenance

Maintenance Procedures Revision Date (The date of the most recent review or revision of maintenance procedures):	14-Apr-2021
Equipment Inspection Date (The date of the most recent equipment inspection or test):	19-Oct-2022
Equipment Tested (Equipment most recently inspected or tested):	Compressor RC-7

Management of Change

Change Management Date (The date of the most recent change that triggered management of change procedures):	17-Mar-2022
Change Management Revision Date (The date of the most recent review or revision of management of change procedures):	14-Apr-2021

Pre-Startup Review

Pre-Startup Review Date (The date of the most recent pre-startup review):	03-Oct-2022

Compliance Audits

Compliance Audit Date (The date of the most recent compliance audit):	14-Apr-2021
Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit):	01-Apr-2024

Incident Investigation

Incident Investigation Date (The date of the most recent incident investigation (if any)):	
Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation):	

Employee Participation Plans

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans):	14-Apr-2021

Hot Work Permit Procedures

Hot Work permit Review Date (The date of the most recent review or revision of hot work permit procedures):	14-Apr-2021

Contractor Safety Procedures

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures):	14-Apr-2021
Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance):	08-Nov-2022

Confidential Business Information

CBI Claimed:	

Section 8. Program Level 2

No records found.

Section 9. Emergency Response

Written Emergency Response (ER) Plan

Community Plan (Is facility included in written community emergency response plan?):	Yes
Facility Plan (Does facility have its own written emergency response plan?):	
Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?):	
Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?):	
Healthcare (Does facility's ER plan include information on emergency health care?):	

Emergency Response Review

Review Date (Date of most recent review or update of facility's ER plan):	

Emergency Response Training

Training Date (Date of most recent review or update of facility's employees):	

Local Agency

Agency Name (Name of local agency with which the facility ER plan or response activities are coordinated):	Jasper County LEPC
Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated):	(417) 624-0820

Subject to

OSHA Regulations at 29 CFR 1910.38:	Yes
OSHA Regulations at 29 CFR 1910.120:	Yes
Clean Water Regulations at 40 CFR 112:	Yes
RCRA Regulations at CFR 264, 265, and 279.52:	
OPA 90 Regulations at 40 CFR 112, 33 CFR 154, 49 CFR 194, or 30 CFR 254:	
State EPCRA Rules or Laws:	Yes
Other (Specify):	

Executive Summary

Description of the Stationary Source and Regulated Substances

Ajinomoto Foods North America, located at 3131 South Quail Avenue, Joplin, MO is a manufacturer of Asian/Ethnic foods and appetizers.

At this facility, anhydrous ammonia (cas #7664-41-7) is used as a refrigerant to cool and freeze product for storage and processing. The refrigeration system at the Joplin, MO facility is a two-stage, closed-loop, mechanical refrigeration system. Liquid ammonia is supplied by pump or pressure to the production and process area evaporators and heat exchangers for cooling and freezing purposes. Ammonia vapor and liquid from the evaporators returns to the suction vessels in the engine room. The normal high-side operating pressure ranges from 130 to 185 psig. The maximum allowable working pressure is 250 to 300 psig. The maximum intended ammonia inventory is 32,024 lbs.

As part of their PSM program, Ajinomoto Foods North America has completed a process hazard analysis, developed written operating procedures, trained employees on awareness and system operation, established procedures to conduct management of change procedures and pre-startup safety reviews, and developed a mechanical integrity program for ammonia refrigeration equipment. In addition to the daily monitoring of the refrigeration process, Ajinomoto Foods North America implements an ongoing preventive maintenance program to ensure the refrigeration equipment and safety systems are maintained in good operating condition.

General Accidental Release Prevention Program and Chemical-Specific Prevention Steps

A PSM program, which meets the requirements of the RMP general accidental release prevention program, is being implemented by Ajinomoto Foods North America to address the anhydrous ammonia refrigeration system at the Joplin, MO facility. The PSM program developed and implemented at Ajinomoto Foods North America includes the following steps:
¿ Written plans for implementing employee participation in PSM.
¿ Process Safety Information: information pertaining to the hazards of ammonia, the technology of the process and the equipment in the process.
¿ Process Hazard Analysis (PHA): A PHA review of the ammonia refrigeration process was conducted to identify hazards and safeguards pertaining to the ammonia refrigeration system.
¿ Operating procedures were developed and implemented for the safe operation of the refrigeration system.
¿ Safe work practices were developed and implemented for lockout/tagout, confined space and opening equipment and piping.
¿ A Mechanical Integrity program is being implemented to maintain the on-going integrity and safety of the refrigeration system, including application of the following industry codes and standards:
o ASME Boiler & Pressure Valve Codes
o ANSI B31.3 Piping Code
o ANSI/IIAR 2-2021 American National Standard for Equipment, Design, and Installation of Closed-Circuit Ammonia Mechanical Refrigerating Systems
o ANSI/ASHRAE Standard 15
o NFPA guidelines for fire protection equipment
¿ A Management of Change (MOC) program and procedures were developed to address all proposed changes to the refrigeration system.
¿ Pre-startup Safety Review (PSSR) procedures were developed.
¿ A detailed compliance audit checklist is used to evaluate compliance with the Process Safety Management and Risk Management programs every three years.
¿ Developed incident investigation procedures to analyze and review accidents or near-misses involving the refrigeration system.
¿ Establish a hot work permit system.
¿ Developed and implemented a program to evaluate contractors and contractor employees.

Five-Year Accident History

Ajinomoto Foods North America has not had an accidental release from the ammonia refrigeration system that caused deaths, injuries, or significant property damage on site, or known off-site deaths, injuries, evacuations, sheltering in place, property damage or environmental damage within the last five years.

Emergency Response Program

Ajinomoto Foods North America employees have not been trained in emergency response and will not respond to emergency ammonia releases. An Emergency Action Plan (EAP) has been developed that includes coordination with local response agencies, procedures for employees to follow in the event of an accidental release of ammonia and a list of emergency phone numbers. Employees have been trained on how to use the plan and drills carried out annually.

Planned Changes to Improve Safety

Through the accidental release prevention program, Ajinomoto Foods North America regularly evaluates the need for any changes to improve safety. Currently, there are no changes planned for the anhydrous ammonia refrigeration system.